

Tuesday, July 22, 2014 8:45:33 AM

649-4901
B122752
REV. A

122752

Page 1

Revision ID:

Item Name: Upper Cutter Assy

Start Date: 7/21/14 **Start Qty:** 1.00

Required Date: 7/21/14 **Req'd Qty:** 1.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:**Customer:**

Approvals: Process Plan: MLS Date: 1-07-23 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop ***NR2***

[illegible]

JAN 13 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 122752***122752***

Page 2

Tuesday, July 22, 2014 8:45:33 AM

Item ID: 649.4901

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Cutter Assy

Start Date: 7/21/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/21/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>SCP25</u>	0.00							
140									
Packaging	Memo	0.00							DAS
Packaging	***IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P# AND REV***							JAN 19 2015	9-89
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

15-1-19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

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Training									
Transport									
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Picklist Print

Tuesday, July 22, 2014 8:45:32 AM

Page 1

Work Order ID: 122752

122752

Parent Item: 649.4901

649 4901

Parent Item Name: Upper Cutter Assy

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
649.8301 *649 8301* Cutter Sub Assembly		Manufactured	No			110	Each	0.0000	1	1	DAS 41 9-89	15-1-12	
					127694				**				
649.5311 *649 5311* Upper Deflector		Manufactured	No			110	Each	22.0000	1	1	DAS 41 9-89	15-1-12	
									**				

Location	Loc Qty	Loc Code
CA	22	
108560	10	
108716	9	
m127615	3	

MS27039-08-19

Purchased

No

110

Each

1,378.000

3

3

DAS
41
9-89

15-1-12

MS27039-08-19

Screw

Location	Loc Qty	Loc Code
ST506	1378	
124309	25	
125654	78	
m127410	275	
m127904	1000	

130505

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Design									
Doc/Data									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 2

Tuesday, July 22, 2014 8:45:32 AM

Work Order ID: 122752

122752

Parent Item: 649.4901

649 4901

Parent Item Name: Upper Cutter Assy

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

110

Each

7,774.000

6

6

DAS

41

9-89

15-1-12

NAS1149FN832P

Washer

130388

Location

Loc Qty

Loc Code

ST275

7774

123185

30

123522

400

123900

2

125268

7342

6

MS21042L08

Purchased

No

110

Each

4,149.000

3

3

DAS

41

9-89

15-1-12

MS21042L08

Nut

130385

Location

Loc Qty

Loc Code

ST306

4149

123900

1

125445

268

m127304

99

m127410

1398

m128401

1500

m128429

683

m129541

200

3

Tuesday, July 22, 2014 8:45:32 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03526

SHEET 1 OF 1

DWG NO. 649.4900

REV: A

PREPARED
BY

S. COCHRAN

DATE: 05-29-12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER ASSY

APPROVED BY:

ENGR

MFG

QC

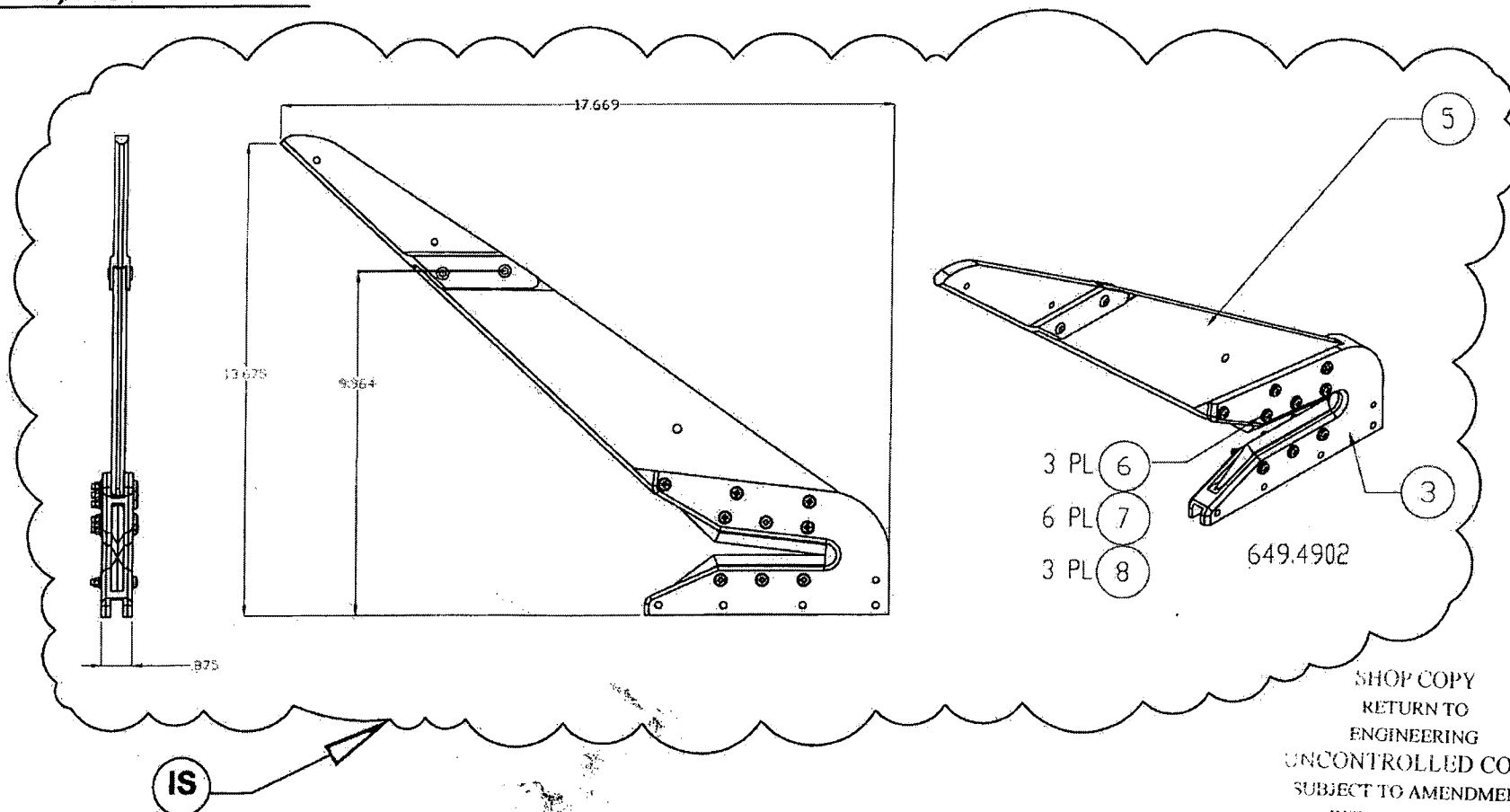
EFF:

CURRENT STOCK & NEXT ORDER

TRANSACTION CODES (TC)
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED INSPECTION DIMENSIONS

SHEET 1, ZONE D2 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

No. 122752 MJS
1407-23

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

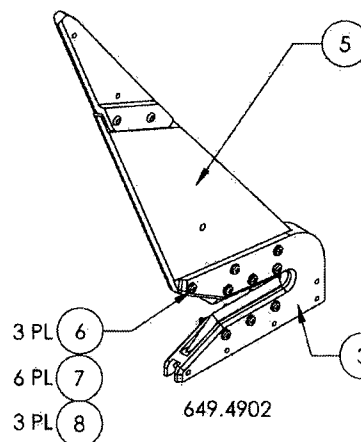
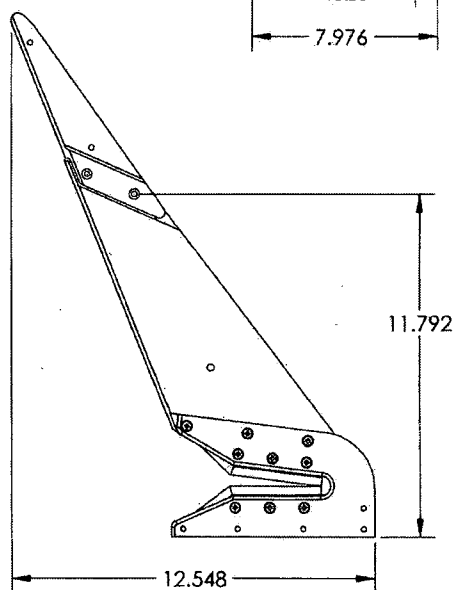
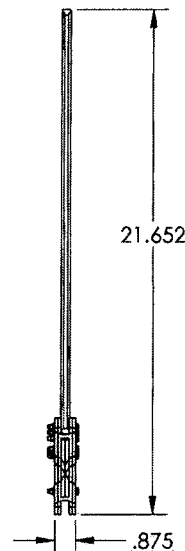
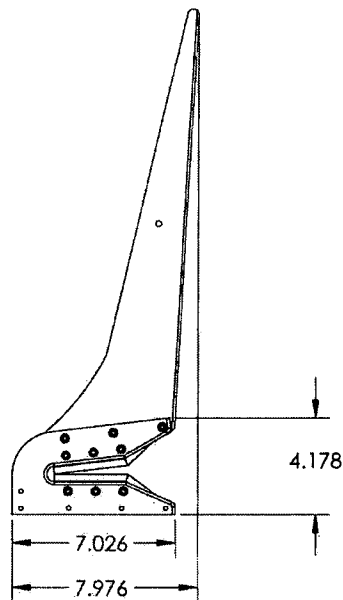
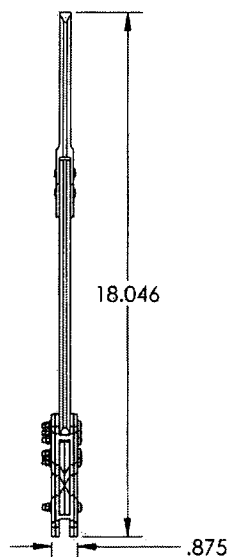
DER REVIEW REQUIRED
☐ YES ☒ NO

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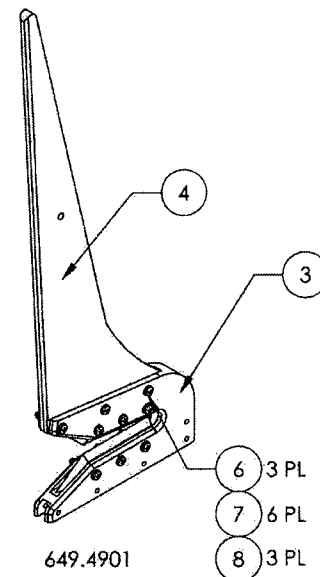
1. IDENTIFY IAW MPP-120.

UNINCORPORATED ECN(s)

026246



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISIONS, P12		N/A
N/C	INITIAL RELEASE	12-07-11	P. BRAVO
A	INCORPORATED ECNS 026246 & 026490	04-17-2012	J. GARDNER



3	3	8	601.1541	LOCKNUT	MS21042L08	
6	6	7	601.2764	WASHER	NAS1149FNB32P	
3	3	6	601.2765	SCREW	MS27039-0819	
1		5	649.5301	LOWER DEFLECTOR ASSY		
	1	4	649.5311	UPPER DEFLECTOR		
1	1	3	649.8301	CUTTER SUB ASSY		
		2	649.4902	LOWER CUTTER ASSY		
		1	649.4901	UPPER CUTTER ASSY		
4902	4901	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		NEXT ASSY (S)		PARTS LIST	
				ORIGINAL DATE 04-17-2012 DRAWN BY J. COCHRAN CHECKED P. BRAVO DRAWING APPROVAL P. BRAVO 04-17-2012 CONTRACT NO.	
				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
				CUTTER ASSY 649.4900	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS .010 2 PLACE DECIMALS .005 ANGLES ± .5°	
				SEE CAGE CODE DWG. NO. B 07M16	
				SCALE NONE SHEET 1 OF 1	